

49

SPLIT

DART AEROSPACE LTD		Work Order:	21843 B
Description: Bearpaw Kit (23" x 19")		Part Number:	K10010
Dwg: D2421 Rev. F1 F2		Qty:	5 10 Kits
Ref: K10010 Rev. A; DSK086-4 Rev. A		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10010 Kit consists of Qty (2) D2421 Dwg not required	JF	04.11.02	5 10
2	DC	Photocopy bluefile: K10010 D900-619-011 D105-645-011 and create labels per PPP K10010 CHG003 (Bag Bluefiles separately)	WK 47 JF	04.11.04	10
3	GA	Cut 2 blanks per (1) K10010 Kit Cut blank: 19.50" x 23.50" x 1.00" thick (+0.030/-0.000) per DSK086-4 Material: Black UHMW 1" (MUHMWB10)	Batch: M15926	JW	04/11/02 5
4	MV	Inspect material for defects or damage prior to machining	JW	04/11/02	5
5	MV	Machine as per Folio FA124 and Dwg D2421 Identify as D2421	JW	04/11/03	3
6	QC2	Inspect parts as they come off the CNC machine	JW	04/11/03	3
7	MV	Deburr	JW	04/11/03	3
8	QC8 & 5	Second inspection	JW	04/11/04	3
9	KP	Pick: Packing Kit (Note: D2421 is on the BOM as material from step 3)			
		Qty Part Number Description Batch			
		4 D2182B060 Rubber Cushion B21185			
		8 D2274 Radius Block B21585			
		2 D2421 Bearpaw B21843			
		4 D2519 Clamp B14649			
		8 D2529 Washer B21587A			
		8 AN4-15A Bolt M15321			
		8 AN960JD416 Washer M15321			
		8 MS21042L4 Nut (or -4) M15020			
		4 QS100M24S Clamp M9523/M1721			
		1 Paperwork package from Step 2 ✓			
10	QC4	Inspect Kit for 100% Completeness on the W/O	JL	04-11-04	54
11	PK	Identify and pack for shipping as per PPP K10010	JL	04/11/04	54
12	AC	Cost / part 213.08	JW	04.11.08	Y
13	DC	Close W/O 207.37 Inspect Level 21	JF	04.11.10	4

Rev	Date	Change	Revised By	Approved
A	00.03.21	K10010 created for Bearpaw (MPP 2037)	EC	
B	03.05.26	Reformat; Incorporated D2421	KJ/RF	
C	04.02.17	Blank size changed on Step 3	KJ/JLM	#

BB 04-11-08 JF

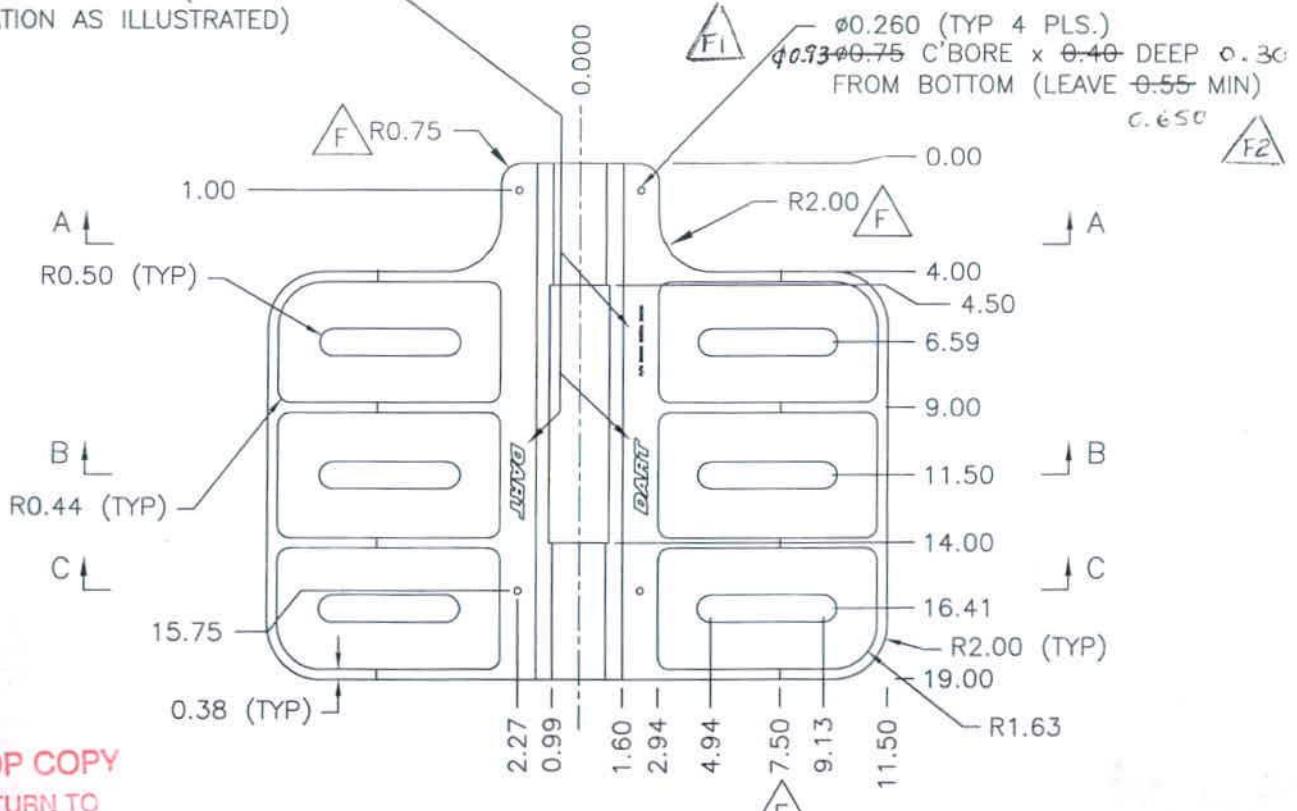
DART

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01.03.14

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
RF	RF	D2421	SHEET 1 OF 2
DATE	TITLE		SCALE
01.03.12	BEARPAW		1:7
A	95.04.24	NEW ISSUE	
B	95.11.28	CHANGED NUMBER OF HOLES	
C	97.06.19	ADDED MATERIAL SPECIFICATION	
D	98.08.11	DIM MODIFICATIONS	
E	00.03.01	R1.77 WAS R2.66; ADD R1.85 BORE RELIEF FOR CLAMPS; ADDED DEO 9155	
F	01.03.12	MODIFY FWD END	
F1	03.01.13	Ø0.93 WAS Ø0.75; R0.19 WAS R0.38; 0.19 WAS 0.25	
F2	04.11.03	0.30 WAS 0.40; 0.650 WAS 0.55	

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



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SYMMETRIC ABOUT CENTER LINE

PRELIMINARY ISSUE

WORK ORDER

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,

NO. 21843 B 1.00" THICK (MACHINE TO 0.950)

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ALGEBRAIC NUMBER THEORY

DOUG
MCKEEAN

10/10

10/10/2010

10/10/2010

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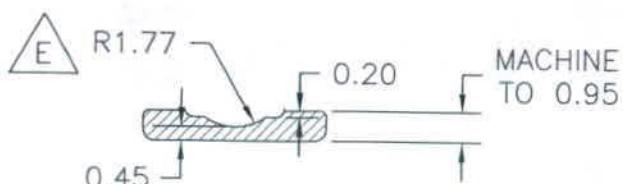
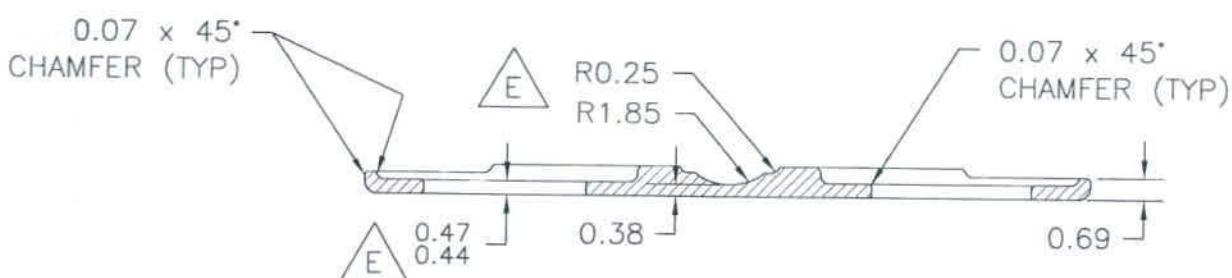
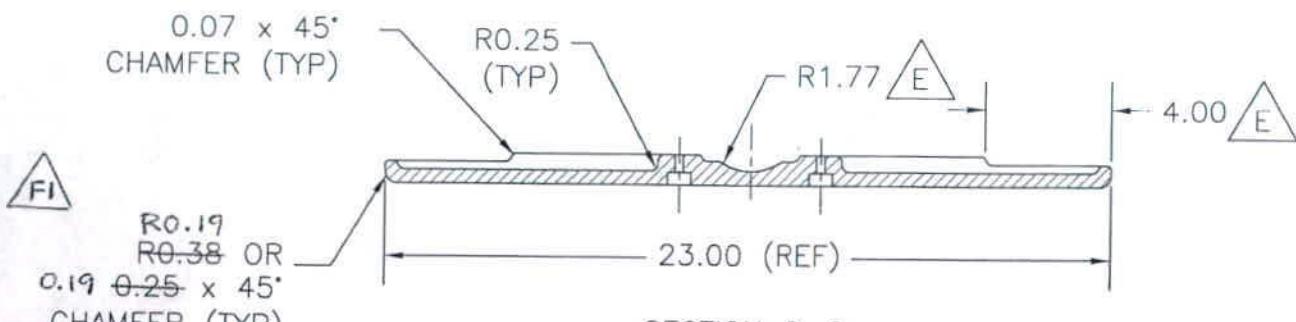
10/10/2010

DART

DESIGN <i>CH</i>	DRAWN BY <i>CH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RF</i>	APPROVED <i>CH</i>	DRAWING NO. D2421
DATE 01.03.12		REV. F SHEET 2 OF 2 SCALE 1:6

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01.03.14 *CH*

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WORK ORDER**NO. 21843-B**SECTION A-ASECTION B-BSECTION C-C**PRELIMINARY ISSUE****Copyright © 1995 by DART AEROSPACE LTD**

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DART AEROSPACE LTD	Work Order:	21843 B
Description: Bearpaw	Part Number:	D2421
Inspection Dwg: D2421	Rev: F1 F2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.20	+/-0.030	0.197	✓	—	vern	
B 0.95	+/-0.030	0.958	✓	—	vern	
C 0.45	+/-0.010	0.448	✓	—	vern	
D 0.07 x 45°	+0.030/-0.010	0.06 x 45°	—	—	vern	
E 0.69	+/-0.030	0.695	—	—	vern	
F 0.38	+/-0.010	0.378	✓	—	vern	
G 0.44 - 0.47	+/-0.000	0.448	—	—	vern	
H R0.25	+/-0.030	R0.25	—	—	R-L	
I 0.19 x 45°	+/-0.030	0.18 x 45°	—	—	vern	
J 23.00	+/-0.030	23.00	✓	—	M-Tape	
K Ø0.260	+0.005/-0.000	Ø0.260	—	—	vern	
L Ø0.93	+/-0.030	Ø0.928	—	—	vern	
M Ø40 Ø30	+0.030/-0.000	0.305	—	—	vern	
N 4.50	+/-0.030	4.50	✓	—	vern	
O 9.50	+/-0.030	9.50	✓	—	vern	
P 1.00	+/-0.030	1.00	—	—	vern	
Q 14.750	+/-0.010	14.750	✓	—	M-Tape	
R 0.38	+/-0.030	0.382	—	—	vern	
S 4.54	+/-0.010	4.54	✓	—	vern	
T 19.00	+/-0.030	19.00	—	—	M-Tape	

125
2014-11-03

Measured by:	<i>TNL</i>	Audited by:	<i>EP</i>	Prototype Approval:	N/A
Date:	<i>04/11/03</i>	Date:	<i>04/11/03</i>	Date:	<i>N/A</i>

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/o K10010	KJ/RF

RELEASED

PT 04.01.15

